

Work Order ID 57349

April 6, 2010 8:20:17 AM



Page 1

Item ID: D3670-4-200

Accept



Setup Start



Revision ID:

Item Name: SPACER

Stop



Start Date: 06/04/2010 Start Qty: 100.00

Required Date: 09/04/2010 Req'd Qty: 100.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-11-06*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3670 Rev A

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

0.00

Memo

0.00

1-TURN AS PER FOLIO FA711 & DWG D3670 ☐ FOLIO REV: *A* ☐ DWG
REV: *A* ☐ 2-DEBURR AS REQUIRED

SA 10/04/06

95



110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SA 10/04/06

95



120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

MCD

10/04/06

95



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57349

April 6, 2010 8:20:17 AM



Page 2

Item ID: D3670-4-200

Revision ID:

Item Name: SPACER

Start Date: 06/04/2010 Start Qty: 100.00

Required Date: 09/04/2010 Req'd Qty: 100.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: LG

0.00

Memo

0.00

95

BE 10/04/12

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/13

BS 10-4-13

(95)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:20:21 AM

Page 1

Work Order ID: 57349

Parent Item: D3670-4-200

Parent Item Name: SPACER

Comments:

Start Date: 06/04/2010

Required Date: 09/04/2010

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No				f	36.0000	36.0180			



ALUM TUBE .3125 x .058w



Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT013

112142

36

36

36 R+ SA 10/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

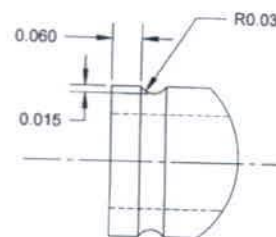
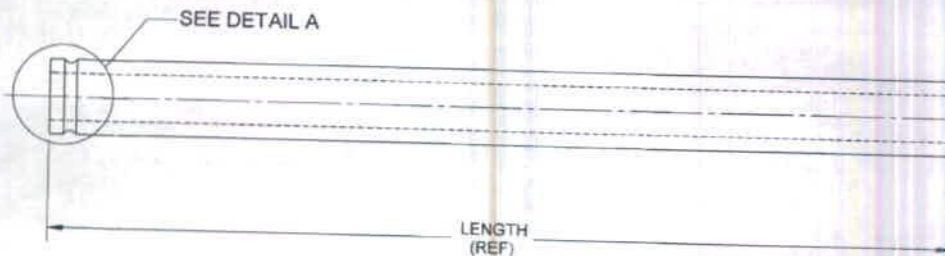
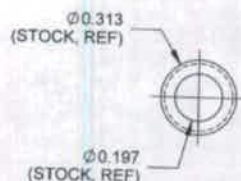
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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



DETAIL A
(SCALE 4 : 1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 573419
BS10-4-06

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

RELEASED
07.11.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

REV.	DESCRIPTION	DC	DATE
A	NEW ISSUE		07.10.19
DESIGN	DC		
DRAWN	DC		
CHECKED	h		
MFG. APPR.	SP		
APPROVED	W		
DE APPR.			
DATE	07.10.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3670

TITLE
SPACER

REV. A
SHEET 1 OF 1

SCALE
2:1

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